

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 68472

Wednesday, April 13, 2011 4:17:04 PM



Page 2

Item ID: D3463-041

Accept



Setup Start



Revision ID:

Item Name: Step Weldment Assembly

Stop



Start Date: 4/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M 116 964.

Memo

0.00

2

BL 11-5-D84

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M 1173/100

Memo

0.00

X2 φ M 1105/24

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Lynn 10/26/2012

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 68472

Page 3

Wednesday, April 13, 2011 4:17:04 PM

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Accept



Setup Start



Revision ID:

Item Name: Step Weldment Assembly

Stop



Start Date: 4/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
Tool ID
Tool #
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

160



Packaging

Packaging

Identify as per dwg & Stock Location: 494

0.00

1440125 2

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/15/2011 JJ
MF
11-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, April 13, 2011 4:17:11 PM

Work Order ID: 68472



Parent Item: D3463-041



Parent Item Name: Step Weldment Assembly

Start Date: 4/13/2011

Required Date: 4/20/2011

Comments: IPP REV. A 05.11.18 new issue EC
with wing walk DD 10.01.28 verified by:EC

IPP revB: replace pressure

Start Qty: 2 00

Start Qty: 2.00

Required Qty: 2.00

Required Qty: 2.00

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, April 13, 2011 4:17:11 PM

Work Order ID: 68472



Parent Item: D3463-041



Parent Item Name: Step Weldment Assembly

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 2.00

Required Qty: 2.00

D3463-5

Manufactured No

100

Each

21.0000

2

4



EL 11-5-18

End Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	21	
58928	21	

D3463-7

Manufactured No

100

Each

1.0000

1

2



EL 11-5-78

Drag Arm

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA025	1	
59199	1	

62813

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

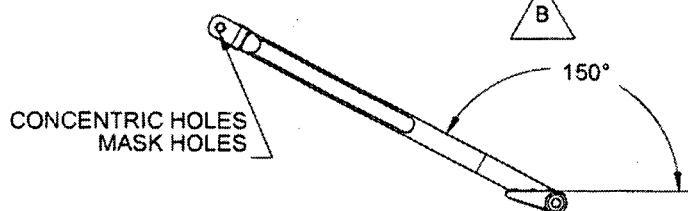
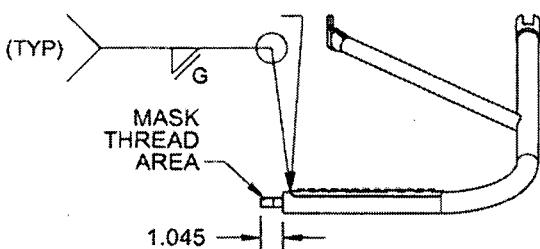
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

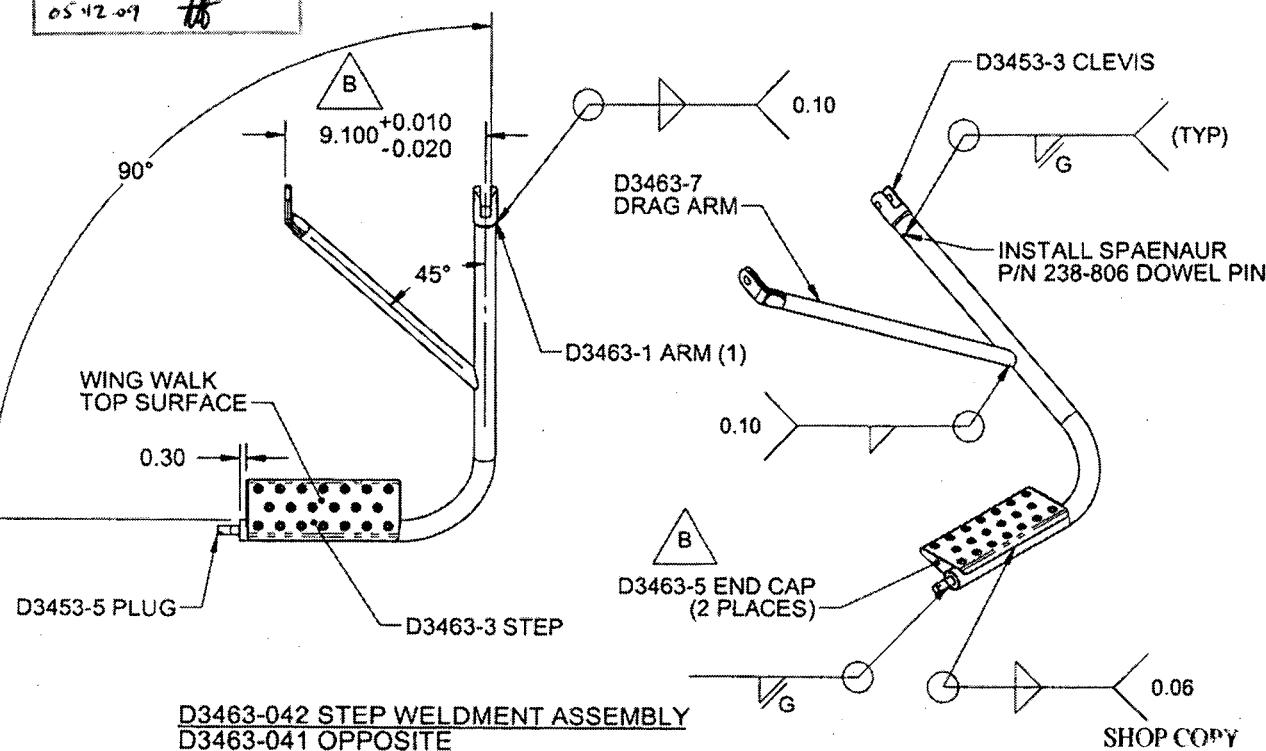
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CHECKED	APPROVED	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE	05.12.05	TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

INSTALL P/N 238-806
DOWEL PIN



RELEASED

05-12-09 *tb*



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68472*

M1104-13

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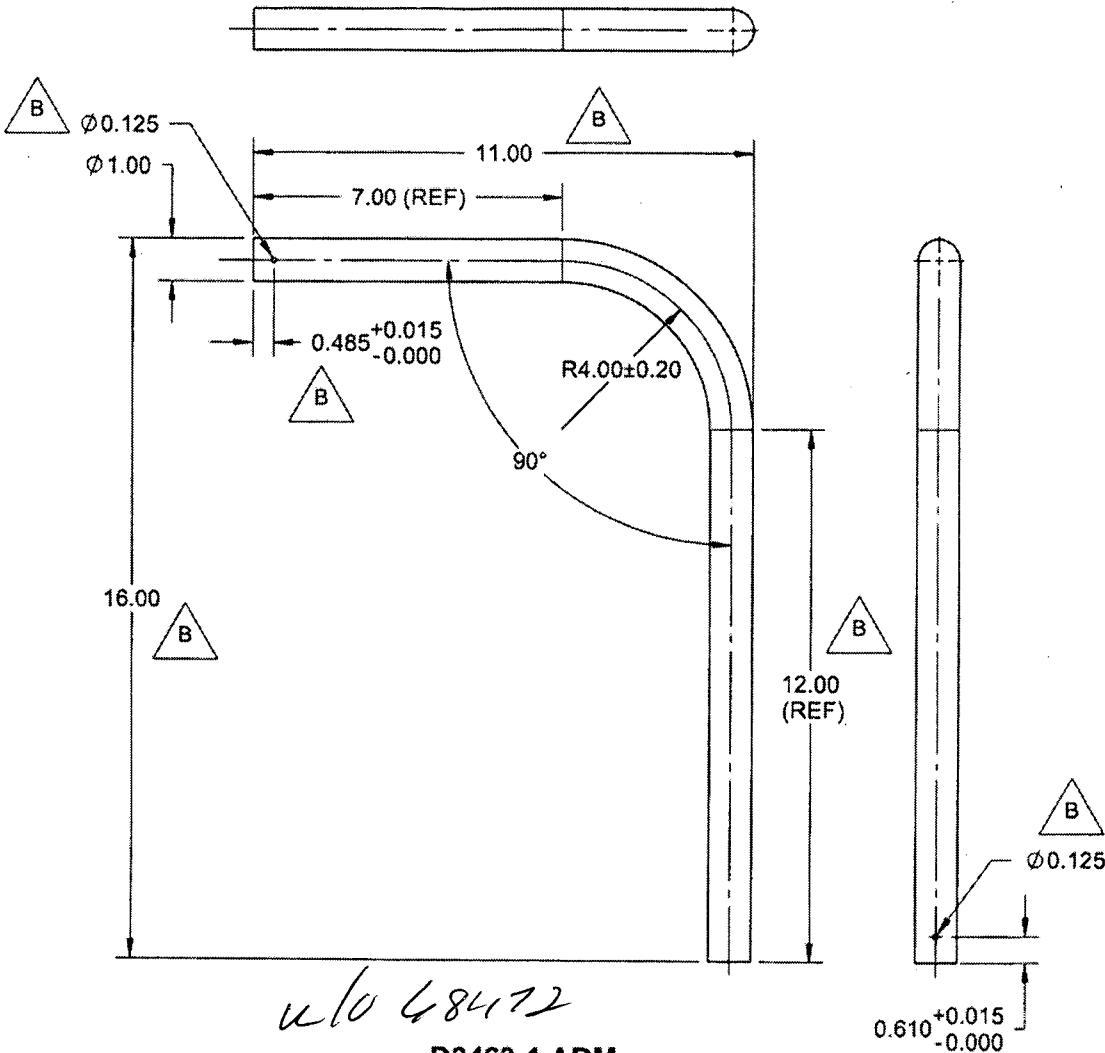
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT	SCALE 1:4	

RELEASED

05.12.05 *[initials]*



NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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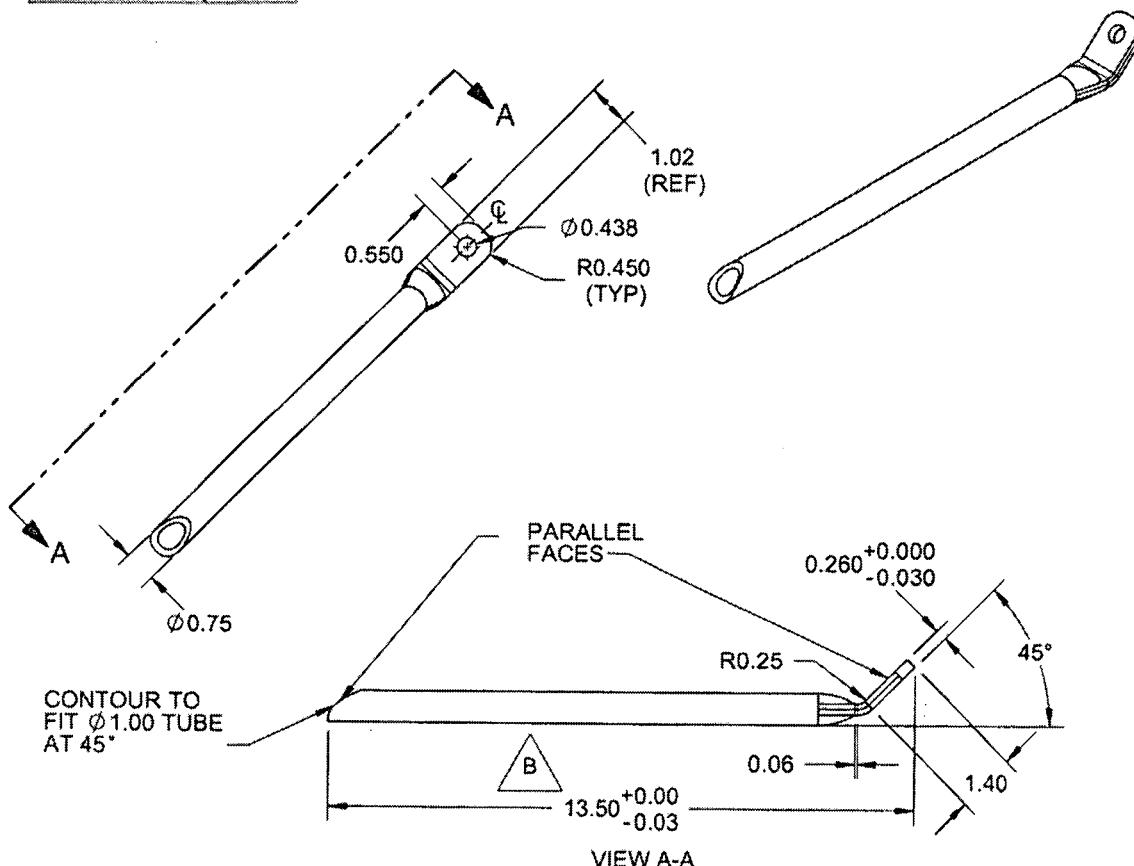
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT	SCALE 1:4	

RELEASED

05.12.05 *#*



D3463-7 DRAG ARM

u/o 684172

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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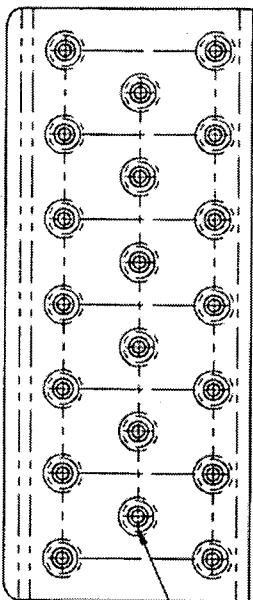
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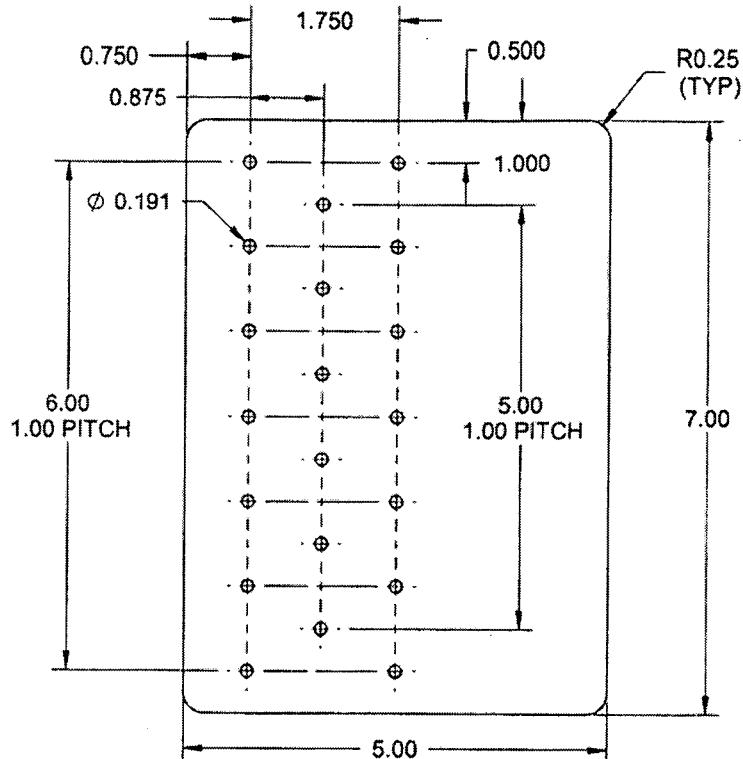
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463
DATE 05.12.05		REV. B SHEET 4 OF 4 TITLE STEP WELDMENT SCALE 1:2

RELEASED

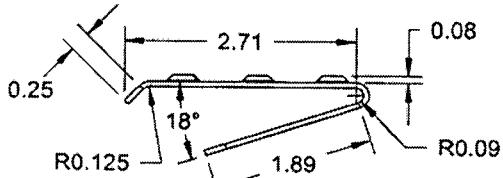
05.n.09 *[initials]*



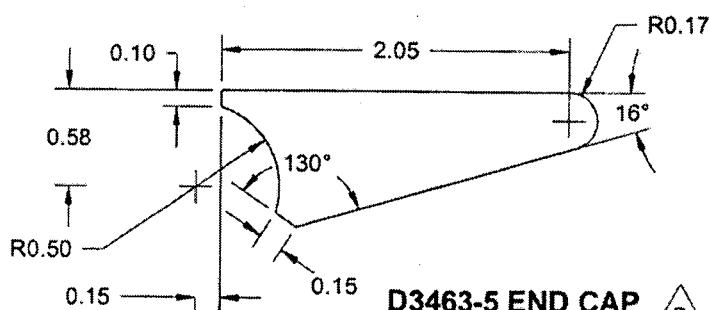
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP

SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

u1068472